

IN THE CLAIMS:

1. (Currently Amended) A method of continuously forming conduit comprising:
continuously applying at least one thin film ribbon, each having "leading" and "trailing"
lateral edges, spirally around a former rotating and advancing said conduit, with the leading edge
5 of each turn of ribbon overlapping the trailing edge of a previous turn of ribbon on the former
and the trailing edge of each turn under lapping the leading edge of a succeeding turn, while,
in advance of said overlapping of said turns, applying a bead of molten plastic, having
"leading" and "trailing edges, adjacent along the exposed trailing edge of the most recently
applied turn on said former, such that said bead is interposed between said trailing edges and said
10 the overlapping leading edges; and under lapping portions, said bead when cooled forming a
helical reinforcing bead and wherein each film ribbon is sufficiently supple, at least laterally, to
conform
said overlapping portion conforms to the contour of said bead, so that said overlapping
edge portion of said ribbon meets or substantially meets said trailing edge of said under lapping
15 portion of said ribbon at an the trailing edge of said bead.

2. (Canceled)

3. (Original) A method of continuously forming conduit as claimed in claim 1, wherein said
20 ribbon is a breathable plastic material.

4. (Previously Presented) A method of continuously forming conduit as claimed in claim 3, wherein said ribbon is a laminate where a layer of breathable plastic material is laminated to a reinforcing layer which also allows the passage of water vapor.

5 5. (Original) A method of continuously forming conduit as claimed in claim 1, wherein said thin film ribbon has a thickness of less than 50 microns.

6. (Original) A method of continuously forming conduit as claimed in claim 1, wherein said method further comprises the steps of,

10 applying one or more heating wires to the exposed trailing edge of the ribbon prior to applying the bead, such that the bead encapsulates the said one or more heating wires onto the said trailing edge.

7. (Currently Amended) A method of continuously forming conduit as claimed in claim 1, 15 where the former includes a plurality of rotating rods spaced about an axis and acting to support and advance the conduit during forming, further comprising:

first applying a sacrificial layer of thin plastic directly around said former, before said conduit is formed on said former over top of said sacrificial layer, and
subsequent to forming said conduit, removing said sacrificial layer from inside said thin
20 walled conduit after cooling.

8. (Original) A method of continuously forming conduit as claimed in claim 7, wherein said sacrificial layer is a thin ribbon having “leading” and “trailing” lateral edges, and said sacrificial layer is spirally wound around said former in a continuous fashion, with the leading edge of each turn of said sacrificial layer overlapping the trailing edge of a previous turn of said sacrificial
5 layer on the former and the trailing edge of each turn under lapping the leading edge of a succeeding turn.
9. (Original) A method of continuously forming conduit as claimed in claim 7, wherein said sacrificial layer is of a material having a different base polymer than that of said conduit, such
10 that no substantial adhesion occurs when adjacent layers of said sacrificial layer and said conduit are heated.
10. (Previously Presented) A method for continuously manufacturing conduit comprising:
applying a sacrificial layer of thin plastic around a former in an overlapping pattern,
15 said former rotating and advancing said conduit,
forming a conduit on said former overtop said sacrificial layer,
welding said overlapping layers to each other, and
removing said sacrificial layer from inside said conduit.
- 20 11. (Original) A method for manufacturing conduit as claimed in claim 10, wherein said sacrificial layer is a thin ribbon having “leading” and “trailing” lateral edges, and said ribbon is spirally wound around said former in a continuous fashion, with the leading edge of

each turn of ribbon overlapping the trailing edge of a previous turn of ribbon on the former and
the trailing edge of each turn under lapping the leading edge of a succeeding turn.

12. (Original) A method for manufacturing a conduit as claim 10, wherein said sacrificial
5 layer is of a material having a different base polymer than that of said conduit, such that no
substantial adhesion occurs when adjacent layers of said sacrificial layer and said conduit are
heated.

13. (Original) A method of continuously forming conduit as claimed in claim 10, wherein
10 said conduit has a wall thickness of less than 400 microns.

14. (Withdrawn) A conduit formed by a method according to any one of claims 1 to 9.

15. (Withdrawn) A conduit formed by a method according to any one of claims 10 to 13.

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16. (Withdrawn) A conduit comprising: at least one thin plastic ribbon having a leading and a
trailing lateral edge, said ribbon arranged helically with its face substantially parallel with the
helix axis, and, apart from at its ends, the leading edge of each turn of ribbon overlapping the
trailing edge of a previous turn, and the trailing edge of each turn of ribbon under lapping the
20 leading edge of a succeeding turn, a plastic reinforcing bead interposed between each
overlapping leading and trailing edge.

17. (Withdrawn) A conduit as claimed in claim 16, wherein said ribbon is of a breathable plastic material.

18. (Withdrawn) A conduit as claimed in claim 16, wherein said plastic reinforcing bead
5 includes one or more heating wires encapsulated in said bead.

19. (Withdrawn) An apparatus for continuously forming conduit comprising: a former for receiving at least one thin plastic ribbon, said former drawing said ribbon around and advancing said ribbon along to procure a helical arrangement of said ribbon, the pitch of said helical
10 arrangement being somewhat less than the width of said ribbon, means for delivering a ribbon to said former at a first position on said former, and means for continuously delivering a molten bead to said former at a second position less than one turn pitch from the first position of delivery of said ribbon, said second position corresponding to an expected position of the trailing edge of a ribbon delivered by said means for delivering a ribbon.

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20. (Withdrawn) An apparatus for continuously forming conduit comprising: a former for receiving plastic ribbon, said former drawing said ribbon around and advancing said ribbon along, to procure an overlapping helical arrangement of said ribbon, the pitch of said helical arrangement being somewhat less than the width of said ribbon, a first means for delivering a
20 first ribbon to said former, at a first location a second means for delivering a second ribbon to said former, at a location subsequent to said first ribbon, a means for continuously delivering a molten bead to said former at a position less than one turn pitch from the position of delivery of

said second ribbon said position corresponding to an expected position of the trailing edge of
said second ribbon.

21. (Withdrawn) An apparatus for continuously forming conduit as claimed in claim 20,

5 wherein there is no means for applying any material to the outside of said first ribbon before it is
overlaid by said second ribbon.

22. (Withdrawn) A method for removing a releasable inner layer from within a conduit

comprising: placing said conduit, including said inner layer around an elongate shaft having a

10 longitudinal slot, forming an adequate seal toward a first end of said shaft, effective for the
conduit to at least substantially seal said slot, from the surroundings, apart from at the other end
of said shaft, applying suction to said slot, initiating release of said inner layer from said conduit,
removing said conduit from said shaft after said inner layer is released from said conduit.

15 23. (Withdrawn) A method for removing a releasable inner layer from within a conduit as

claimed in claim 22, wherein said step of initiating includes urging said inner layer at a position
toward said other end of said shaft, into said slot, said urging forming an adequate seal between
said shaft and said layer.

20 24. (Withdrawn) An apparatus for assisting removal of a releasable inner layer within a

conduit comprising: an elongate shaft having a longitudinal slot, a effective sealing means for
making an adequate seal between said inner layer and said shaft, toward a first end of said shaft,

a means to suck gases from said slot, and release said inner layer from said conduit.

25. (Previously Presented) A method of continuously manufacturing conduit as claimed in
claim 10, wherein the wall of said conduit is formed from a thin polymer tape having leading and
5 trailing lateral edges, and

said tape is spirally wound around said former (1) in a continuous fashion, with the
leading edge of each turn of tape overlapping the trailing edge of a previous turn of tape on said
former and the trailing edge of each turn of said tape under lapping the leading edge of a
succeeding turn of tape.

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26. (Previously Presented) A method of continuously manufacturing conduit as claimed in
claim 25, further comprising the step of:

applying a bead of molten plastic over top, or between, said overlapping turns of tape and
said bead welding said spirally wound tape to form said conduit.

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27. (Previously Presented) A method of continuously manufacturing conduit as claimed in
claim 26, wherein said step of applying said molten bead over top, or between, said overlapping
layers of tape, welds said overlapping leading and trailing edges of said sacrificial layer of
spirally wound ribbon.

28. (New) A method of continuously forming conduit as claimed in claim 1, wherein said leading edge of said overlapping ribbon meets or substantially meets said under lapping ribbon at the leading edge of said bead.